

Work Order ID 80585

80585

February-23-12 1:23:55 PM

Page 1

Item ID: D412-664-203

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crosstube Aft

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12/02/23 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D412-664-243	E/DEO
--------------	-------

100

100

DC

Document Control

S

0.00

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and create labels as per PPP D412-664-203 CHG 008

WJ 12-03-23 (B)
JW for MLS 12-3-22

110

110

Packaging

Packaging

0.00

JW

12-3-5

Packaging

Memo

0.00

Pto

120

120

CNC Bend 2

CNC Alpha 160 Bender

BENDING MACHINE - CROSSTUBES

0.00

Memo

0.00

Bend tube as per Dwg D412-664-243 using CNC bender program 412-aft and Folio FT010

JW
Rm

12-3-5

D412-664-203/80585

WO: 80585

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-664-203 PAR #: _____ Fault Category: X-tube NCR: Yes No DQA: ✓ Date: 12/03/28
 Resolution: Weld an in Disposition: Weld an in QA: N/C Closed: ✓ Date: 12/3/28

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.03.05	120	CRUSHING AFTER BENDING IS OVER TOLERANCE AT BOTTOM OF BEND	<u>GP</u> 12.03.05 Q51042	Acceptable per attached SR	<u>W</u> / <u>4</u>	<u>S</u> 7/3/05	<u>GP</u> 12.02.05 Q51042	<u>S</u> 7/3/05

NOTE: Date & initial all entries

Work Order ID 80585

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80585

Page 2

Item ID: D412-664-203

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 **Start Qty:** 1.00

1

Cust Item ID:

Required Date: 14/03/2012 **Req'd Qty:** 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

130

QC15- Crosstube Dimensional Check

0.00

130

QC

Quality Control

5/20/3/15

0.00

140

Crosstubes

0.00

140

Crosstubes

Memo

0.00

Crosstubes

1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 and drill table DT8577 using #9 holes as per QSI 10 to install towers.

2-Ream hole to finish size in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Scribe Part # & Batch #

4-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243

MO

12/3/15

MO

12/3/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80585

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Item ID: D412-664-203

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Start

NS1

Revision ID:

Item Name: Crosstube Aft

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

HandFXtube

Hand Finishing Crosstubes

Crosstubes Chemical Conversion

0.00

MO

12 /3/6

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

8.7 (03/07)

Memo

0.00

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5 2/0/17

Memo

0.00

40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						<i>[Signature]</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID 80585

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Item ID: D412-664-203

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Setup

Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 14/03/2012 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

**Sequence ID/
Work Center ID**

**Operation
Description**

**Set Up/
Run Hours**

Tool ID

Tool #

**Plan
Code**

**Accept
Qty**

**Reject
Qty**

**Reject
Number**

**Insp.
Stamp**

180

180

Outsource2

Memo

0.00

12/03/9

Outsource process - NDT

Liquid Penetrant Inspection as per QSI 038Or
Issue P/O: 14399 LPI as per ASTM 1417
Level 2 Attach copy of NDT results to work order

190

190

Packaging

Packaging

0.00

12/3/0

Packaging

Memo
Inspect for transit damage
Ensure copy of NDT results attached to work order.

200

200

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5.2/03/04

Memo
Inspect for damage & ensure results are as per Dwg D412-664-203

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80585

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Item ID: D412-664-203

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

210

SprayPaint

SprayPaint

0.00

A8

12 - 3 - 15

Memo

0.00

Mask underside of crosstube as shown

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per DEO D412-664-243 and QSI 005 4.2

PRIME:

Start Time: 9:45

Finish Time: 10:30

A8 12-3-14

PAINT:

Start Time: 11:15

Finish Time: 12:30

A8 12-3-15

220

220

QC

Quality Control

QC14- Inspect Spray Paint

0.00

Memo

0.00

Then, Wrap in plastic bag to protect from scratches

N
12 - 03 - 19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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80585

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Item ID: D412-664-203

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230		0.00							
230	Crosstubes								
Crosstubes	Memo	0.00							
Crosstubes	Assemble as per Dwg D412-664-203								
	1- Install chafing shield as per DEO D412-664-243. Top holes should be facing up.								
	A/R Proseal 890 Batch: 120867								
	EXP: 11/12								
	2- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe								
	3-Install support with Scotch-Weld DP460 and install clamps as per DEO Dwg D12-664-243 using installation jig DT9024. Torque clamps as per dwg								
	A/R Scotch-Weld DP460 Batch: 120389								
	EXP: 14 Mar. 2013								

240

QC5- Inspect part completeness to step on W/O 0.00

240

QC

Quality Control

m 12 . 03 . 22 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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80585

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Item ID: D412-664-203

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

12/3/2012

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

W 1d 03-23 (1)

270

Packaging

0.00

270

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-664-203

*****Ensure tube is not packaged if curing time is less than 12 hrs, see step 27
for application time & date *****

Time & date of packaging: Rew 2

Location: 103

12/3/23 sf (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80585

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80585

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Item ID: D412-664-203

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Crosstube Aft

Stop

NS2

Start Date: 23/02/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280 *280* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00							12/3/26 JF

12/3/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-23-12 1:23:59 PM

Page 1

Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:E04.02.16Reformat; Added D3189-1K/DS
 IPP Rev:F 06-03-29 Remove Coments on Pick List JLM
 IPP Rev:G 06.12.08 per ECN 886 EC
 IPP Rev:H 07-04-30 As per Rev D JLM
 IPP Rev:I 08-06-12 add comment in seq. 21 DD verified by:EC IPP rev J
 11.04.21 DEO D412-664-243-E-1 EC verified DD IPP REV:K
 11.10.03 DEO D412-664-243-E-2 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D412-664-203TRN		Manufactured	No	B80133		110	Each	2.0000	1	1	JW	12-3-1	
D412-664-203TRN									**				
Crosstube Turning Detail													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG	2					
							80128	1					
							80131	1					
D2896-1		Manufactured	No			230	Each	22.0000	1	1			
D2896-1									**				
Support													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							LG053	22					
							(1502)	1					
							74465	21					
D3189-1		Manufactured	No			230	Each	37.0000	2	2			
D3189-1									**				
Chafing Shield													
							<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>				
							FG	4					
							36065	4					
							LG053	33					
							(6473)	22					
							79796	11					

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 2

Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3595-063-570

Manufactured No

230

Each

114.0000

2

2

**

A8 12-3-20

D3595-063-570

RUBBER CUSHION

Location	Loc Qty	Loc Code
----------	---------	----------

FG	8	
----	---	--

37971	1	
-------	---	--

42243	7	
-------	---	--

MAT052	106	
--------	-----	--

71534	29	
-------	----	--

76546	77	
-------	----	--

2		
---	--	--

MS21920-28

Purchased No

230

Each

39.0000

4

4

**

A8 12-3-20

120884

Location	Loc Qty	Loc Code
----------	---------	----------

FG	5	
----	---	--

105884	5	
--------	---	--

LG050	34	
-------	----	--

116839	2	
--------	---	--

118713	4	
--------	---	--

119285	1	
--------	---	--

119920	1	
--------	---	--

120054	26	
--------	----	--

2		
---	--	--

MS21920-30

Purchased No

230

Each

80.0000

2

**

A8 12-3-20

MS21920-30

clamp(per MIL-DTL-8783C)

Location	Loc Qty	Loc Code
----------	---------	----------

LG	50	
----	----	--

119529	50	
--------	----	--

LG050	16	
-------	----	--

117998	16	
--------	----	--

LG051	14	
-------	----	--

111258	14	
--------	----	--

2		
---	--	--

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 80585

80585

Parent Item: D412-664-203

D412-664-203

Parent Item Name: Crosstube Aft

Start Date: 23/02/2012

Required Date: 14/03/2012

Start Qty: 1.00

Required Qty: 1.00

AN6-40A

Purchased

No

250

Each

108.0000

4

4

**

M120833 ✓

AN6-40A

Bolt

Location	Loc Qty	Loc Code
ST342	108	
119749	8	
120187	100	

AN6-41A

Purchased

No

250

Each

87.0000

2

2

**

✓

AN6-41A

Bolt

Location	Loc Qty	Loc Code
ST342	87	
119749	20	
120187	17	
120423	50	

AN960JD616

NAS1149D0663J Purchased

No

250

Each

0.0000

18

18

**

M119075 ✓

AN960JD616

Washer

MS21042L6

Purchased

No

250

Each

1,072.000

6

6

**

✓

MS21042L6

Nut

Location	Loc Qty	Loc Code
ST300	1072	
117677	25	
118384	3	
118927	48	
119075	796	
120308	200	

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	80585
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: E		Page 1 of 1

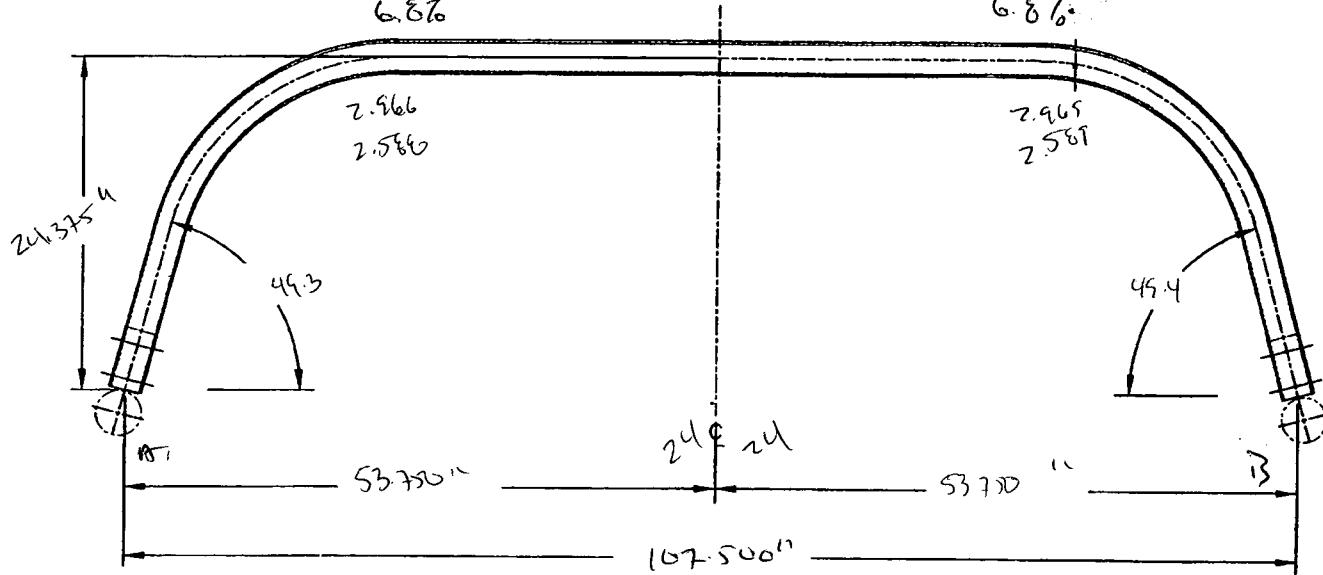
Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70

$378 \div 5.554$

6.876

$380 \div 5.558$

6.876



Comments
SIDE A = 6.876 crushing @ 24 passes.
SIDE B = 6.876 crushing @ 24 passes.

QC15 Inspection	8
Date	07/03/05

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM	
C	10.02.02	Dwg Rev updated	KJ	J

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Item	Qty	Part Number	Description
1	X	D412-664-243	CROSSTUBE ASSEMBLY (412 HIGH AFT)
2	1	D6009-129	CROSSTUBE
3	2	D3595-063-570	RUBBER CUSHION
4	1	D2896-1	SUPPORT
5	2	D3189-1	CHAFING SHIELD
6	2	D2856-600-1009	ABRASION STRIP
7	4	MS21920-28	CLAMP
8	2	MS21920-30	CLAMP (OR MS21920-32)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

STOP COPY

80585 M.C.J

12/02/23

② DEO ATTACHED

RELEASED
2009-10-29
VWGENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6009-129
FINISHED LENGTH = 124.100±0.020 (BEFORE BENDING/TRIMMING)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D412-664-243" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 47.0 lbs (PER IIN-D212-564)
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE THE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT.
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.
- 15) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

E	REFORMAT/REVISE GENERAL NOTES; REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS; RELOCATED FLAG #6 PER PAR 08-046 (ZN A6-3); ADD TOLERANCE (ZN B6-3, C4-3, C8-3 & C5-3); MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	09.09.30
D	REMOVE D2732-058, CHANGE TO D3595-063-570	PH	07.03.09
C	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398, MS21920-32 WAS MS21920-30	MB	06.10.27
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	PH	01.10.17
REV.	DESCRIPTION	BY	DATE
DESIGN	A1	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PP	DRAWING NO.	REV. E
MFG. APPR.	DA	D412-664-243	SHEET 1 OF 4
APPROVED	MO	TITLE	SCALE
DE APPR.	HP	CROSSTUBE ASSEMBLY (412 HI AFT)	NTS
DATE	09.09.30	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS TRADE SECRET INFORMATION WHICH IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

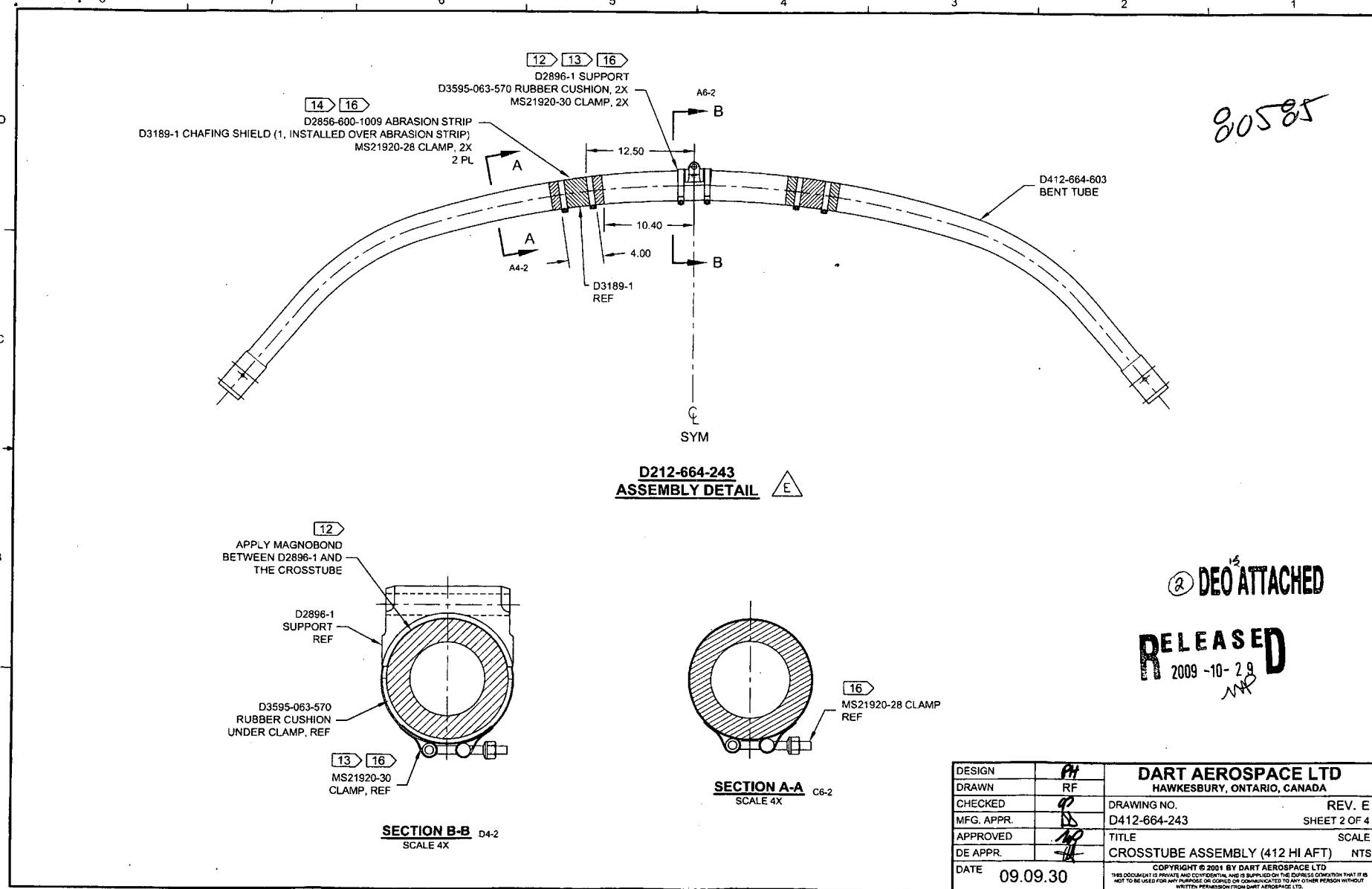
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

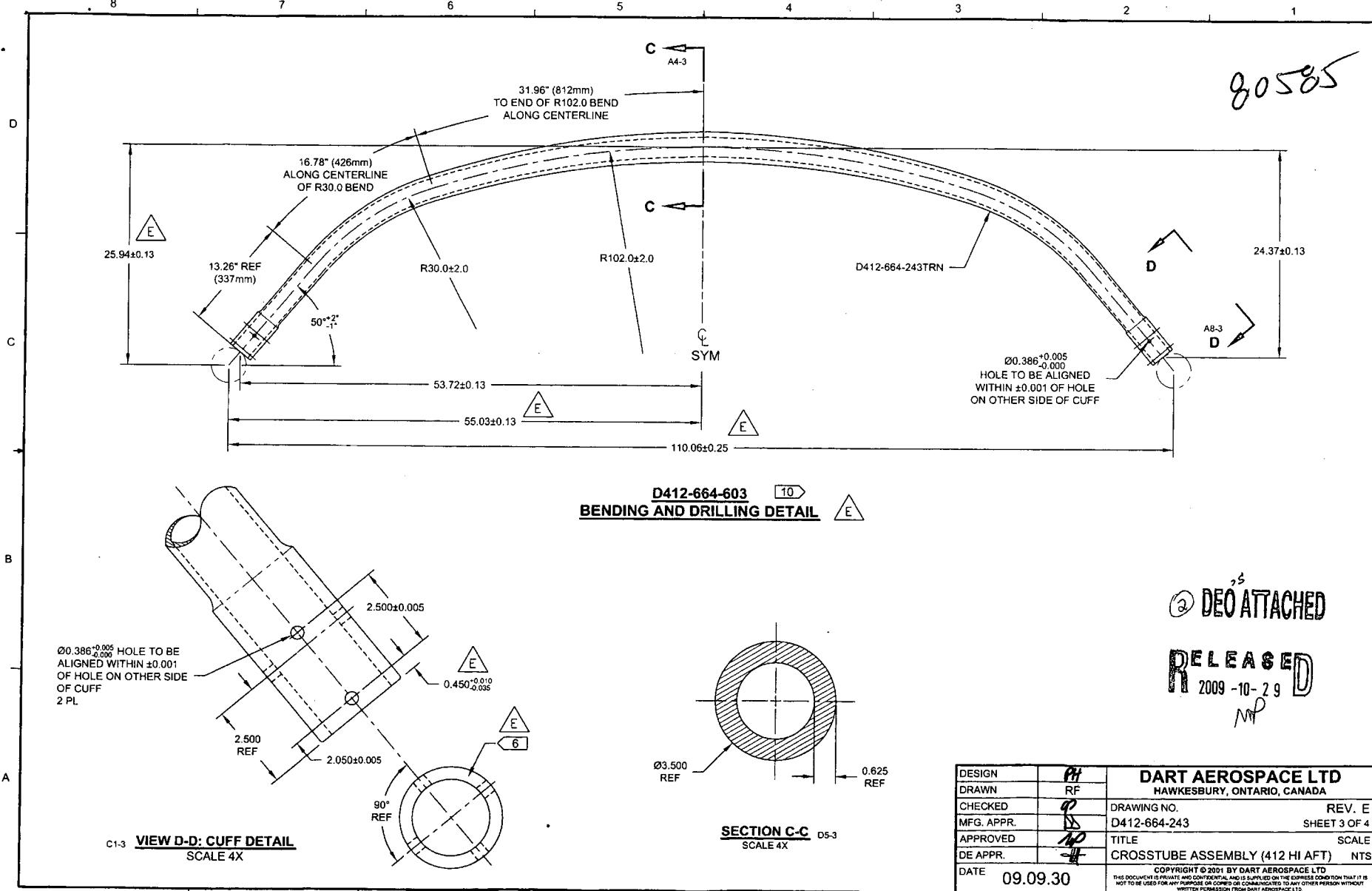
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

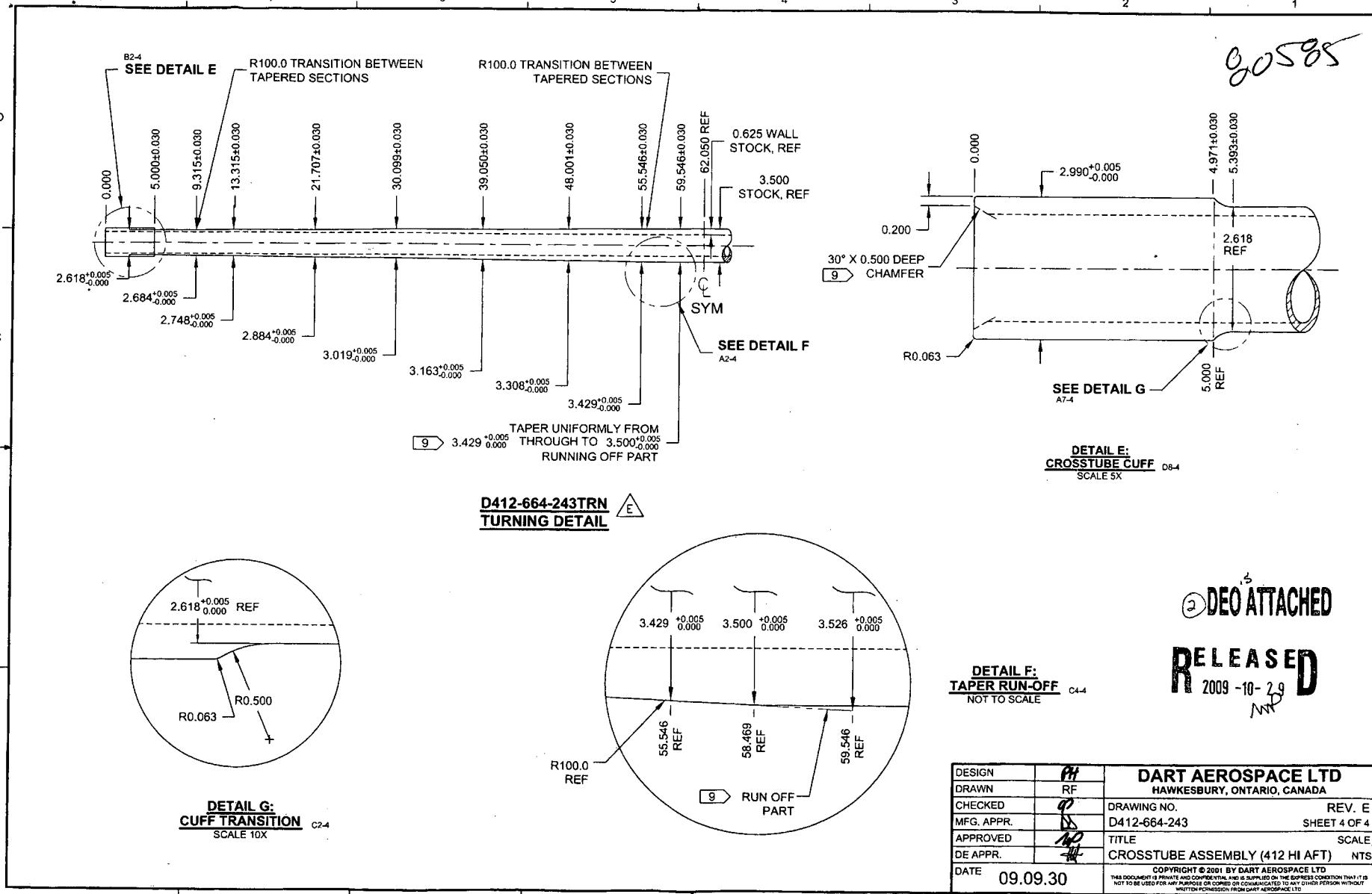
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



80585

② DEO ATTACHED

RELEASED
2009-10-29
MM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 1 OF 2	SCALE NTS
DRAWN <i>MP</i>	CHECKED <i>MP</i>	MFG. APPR. <i>E</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 11.03.31	DATE 11/03/31	DATE 11.03.31	DATE 11/03/31	DATE 11.03.31	DATE 11/03/31	

PURPOSE:

REMOVED ABRASION STRIP IN FAVOR OF A THIN LAYER OF PROSEAL 890.

80<85

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

Item	Qty -243	Part Number	Description
6	0	D2856-600-1009	ABRASION STRIP

WAS:

6	2	D2856-600-1009	ABRASION STRIP

NOTES 2 AND 14, SHEET 1 ARE AMENDED AS FOLLOWS:

IS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
MASK UNDERSIDE OF CROSSTUBE AS SHOWN (HATCHED AREA)
PAINT OUTSIDE PER DART QSI 005 4.2
AFTER PAINTING, APPLY CLEAR COAT ON HATCHED AREA
- 14) APPLY A THIN COAT OF PROSEAL 890 ON INSIDE CONCAVE SURFACE OF D3189-1 CHAFING SHIELD AND LET CURE PER MANUFACTURER'S INSTRUCTIONS. INSTALL PROSEALED D3189-1 CHAFING SHIELD ONTO CROSSTUBE BY APPLYING A THIN COAT OF PROSEAL 890 ONTO CROSSTUBE. BE SURE TO ELIMINATE ANY AIR GAPS.

WAS:

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 14) INSTALL D2856-600-1009 ABRASION STRIPS WITH A 0.13 REF GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.

*RELEASED
2011-04-07
MP*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASSEMBLY (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-664-243-E-1	SHEET NO. SHEET 2 OF 2	SCALE NTS
DRAWN DATE 11.03.31	CHECKED DATE 11.03.31	MFG. APPR. DATE 11.03.31	APPROVED DATE 11.03.31	DE APPR. DATE 11.03.31		80585

IS:

D3189-1 CHAFING SHIELD (1, INSTALLED OVER PROSEAL 890)
MS21920-28 CLAMP, 2X
2 PL

D412-664-603
BENT TUBE

2.00
1.00

16 14

WAS:

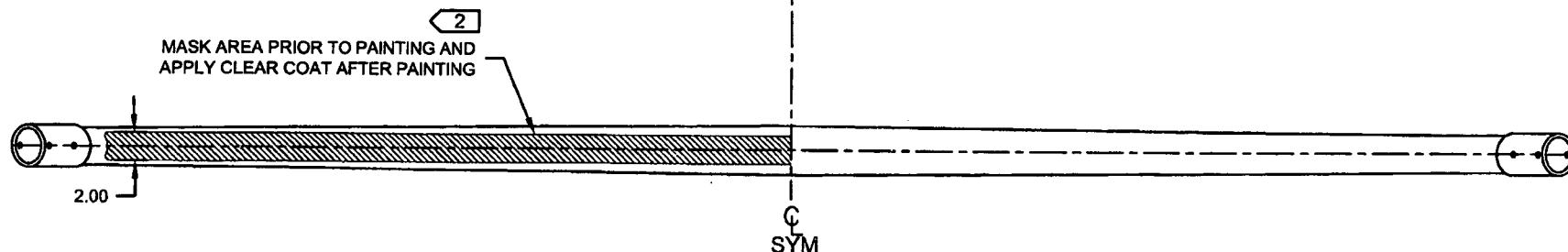
14 16

D2856-600-1009 ABRASION STRIP
D3189-1 CHAFING SHIELD (1, INSTALLED OVER ABRASION STRIP)
MS21920-28 CLAMP, 2X
2 PL

D3189-1
REF

D412-664-243
ASSEMBLY DETAIL

RELEASED
2011-04-07
M4



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D412-664-243	TITLE CROSSTUBE ASS'Y (412 HI AFT)	REV. E	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO. D412-664-243-E-2	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>JP</i>	CHECKED <i>ASS</i>	MFG. APPR. <i>RE</i>	APPROVED <i>MP</i>	DE APPR. <i>MP</i>		
DATE 11.09.07	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19	DATE 11.09.19		

PURPOSE:

REPLACE MAGNOBOND WITH 3M DP460 SCOTCH-WELD EPOXY ADHESIVE

80585

CHANGE:

IS:

Item	Qty -243	Part Number	Description
9	A/R	SCOTCH-WELD DP460	EPOXY ADHESIVE, 3M SCOTCH-WELD

WAS:

9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
---	-----	----------------	---

NOTE 12 & 16, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) INSTALL D2896-1 CENTER SUPPORT USING A 0.04" TO 0.07" THICK LAYER OF SCOTCH-WELD DP460 PER QSI 015. LET CURE FOR 24 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER ADHESIVE HAS CURED FOR 24 HOURS.

WAS:

- 12) INSTALL D2896-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 16) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

RELEASED
2011-09-29
MP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 11/12/06

beam is acceptable
at 8% crushing, 8% yielding in area at end of fibre
so the will break at smaller beam centre before crack

$$M.S. = 19.63 / (1.484 - 1) = 6.27$$

$$\frac{I}{\sigma} = \frac{\pi \times 13 \times 2.96}{2 \times 1.156} = 11.934 \text{ in}^4$$

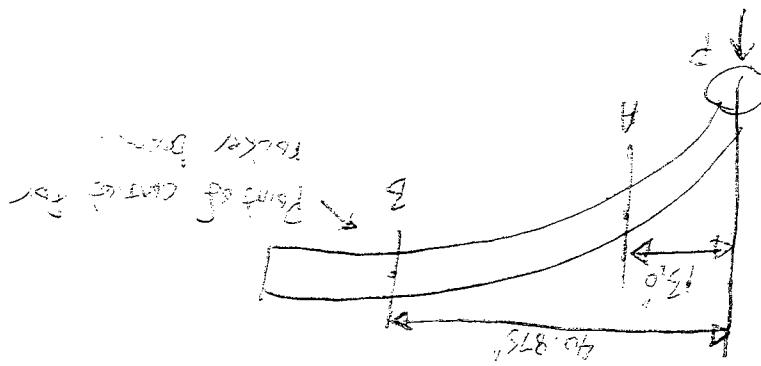
$$\frac{P}{B} = \frac{\pi \times 40.875 \times 3.557}{2 \times 4.113} = 14.651 \text{ kN}$$

$$\text{Ansatz: } Q_1 = 3.327 \text{ in}^3, I = 4.613 \text{ in}^4$$

$$I = 11.676 \text{ in}^4 \text{ (from fibres)}$$

$$\text{CROSSING} = (2.96 - 2.32) / (2.96 + 2.32) = 8\%$$

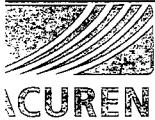
$$\text{Ansatz: } Q_1 = 2.96, Q_2 = 2.32$$



Acceptability of 8% crushing at end of beam

CUSHING OF 042-699-716-664

11/12/06



LIQUID PENETRANT TEST REPORT

P- 05641

CLIENT Acuren Aerospace DATE MARCH-09-2012
 ATTENTION LINDA MASTERS (ANDY) TIME AM PM
 ADDRESS 1370 ABERDEEN STREET
HALIFAX, NS B3H 2L9
 WORK LOCATION AS ADDRESS
 PROJECT PT -> WET Fluorescent Liquid Penetrant on 6 x "ClosSTubes"
 ITEM(S) EXAMINED - SEE Below

JOB DESCRIPTION PROCEDURE NO. LT-003 REV./DATE 2007 TECHNIQUE NO. LT-003 REV./DATE 2007
 ART NO. MATERIAL Aluminum THICKNESS ~ 1/4
 COPE PERFORMED A WET FLUORESCENT L.P.T. ON 100% OF THE EXTERNAL SURFACE OF
ITEMS MENTIONED BELOW

TEST DETAILS

METHOD <input checked="" type="checkbox"/> FLUORESCENT <input type="checkbox"/> VISIBLE	WATER WASH <input checked="" type="checkbox"/> SOLVENT REMOVABLE <input type="checkbox"/> POST EMULSIFIED
FLUID BRAND <u>MAGNAFLUX</u>	BLACK LIGHT S/N <u>13793</u> <input checked="" type="checkbox"/> OUTPUT > 1000 LUMINOSITY @ 2' FC <input type="checkbox"/> AMBIENT < 2 fc
ENETRANT <u>2L-67</u> MINIMUM Dwell TIME <u>10</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT <input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
ENETRANT REMOVER <u>H2O</u> MINIMUM DRY TIME <u>>10</u> MIN.	OTHER
DEVELOPER <u>SRD-S3</u> MINIMUM Dwell TIME <u>10</u> MIN.	LIGHT METER S/N <u>.....</u>
DEVELOPER TYPE <input type="checkbox"/> NON AQUEOUS <input checked="" type="checkbox"/> AQUEOUS <input type="checkbox"/> DRY	CAL DUE DATE <u>10/2012</u>

TEST SURFACE

SURFACE CONDITION <input type="checkbox"/> AS GROUND <input checked="" type="checkbox"/> AS WELDED <input type="checkbox"/> MACHINED <input type="checkbox"/> SHOT BLASTED <input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE <input type="checkbox"/> < -4°C/ 20°F <input checked="" type="checkbox"/> -4°C/ 20°F TO 10°C/50°F <input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F <input type="checkbox"/> > 52°C/125°F
RESULTS- (<input type="checkbox"/> METRIC <input checked="" type="checkbox"/> IMPERIAL)

1 ClosTube w.o. ID 80136 ✓	ITEM ID <u>D412-664-203</u> ART
2 w.o. ID 80137 ✓	ITEM ID <u>D412-664-203</u> ART
3 w.o. ID 8054 ✓	ITEM ID <u>D412-664-203</u> ART
4 w.o. ID 8055 ✓	ITEM ID <u>D412-664-203</u> ART
5 ClosTube w.o. ID 79659 ✓	ITEM ID <u>D412-667-107BL</u> Flu Blue
6 w.o. ID 79743 ✓	ITEM ID <u>D412-667-107BL</u> Flu Blue
No significant indication was detected as per applicable standards.	

8/10/14

Scope of Services
 The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
 In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE <u>Andrew Sheldon</u> PRINT <u>Asheller</u> SIGNATURE <u>.....</u> DTR # <u>E89975</u>
TECHNICIAN (SIGNATURE): <u>WES SHELTON</u> SIGNATURE <u>.....</u> REPORT REVIEWED BY: NAME <u>.....</u> INITIALS <u>.....</u>
JAME (PRINT): <u>.....</u> 1 ST TECHNICIAN <u>.....</u> 2 ND TECHNICIAN <u>.....</u>
CGSB LEVEL <u>.....</u> SNT LEVEL <u>.....</u> CGSB LEVEL <u>.....</u> SNT LEVEL <u>.....</u>
CGSB REG. NO. <u>3044</u> CGSB REG. NO. <u>.....</u>

Location/Lot Activity

Thursday, March 29, 2012 12:36:44 PM

Page 1 of 3

Report on Locations & Lots											
Criteria :	All Items	All Locations	Lot: 71502	All Transaction Types	All Dates	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
Transaction Type	Item ID/ Item Name	Warehouse	Reason	Employee ID	Location Code					Lot Code	
Account Value Change	D2896-1 / Support	Main Warehouse		FAUT01			20.0000		20.0000		
		LG				10/19/2011	-20.0000	71502	-20.0000		(\$6,397.93)
		Main Warehouse		FAUT01			20.0000		20.0000		
		LG				10/19/2011	20.0000	71502	20.0000		\$6,397.93
Inv Adjustment	D2896-1 / Support	Main Warehouse	Found	FAUT01			21.0000		0.0000		\$0.00
		LG053				3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	Found	FAUT01			21.0000		0.0000		
		LG053				3/7/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	B/N correction	GOLD01			21.0000		0.0000		
		LG053				3/23/2012	1.0000	71502	1.0000		\$319.90
		Main Warehouse	B/N correction	GOLD01			21.0000		0.0000		
		LG053				3/27/2012	1.0000	71502	1.0000		\$319.90
Issue	D2896-1 / Support	Main Warehouse	73691 ✓	QUIR01			20.0000		20.0000		\$1,279.59
		LG				10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	73690 ✓	QUIR01			19.0000		19.0000		
		LG				10/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75417 ✓	QUIR01			18.0000		18.0000		
		LG				11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	75416 ✓	QUIR01			17.0000		17.0000		
		LG				11/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	74376 ✓	FAUT01			16.0000		16.0000		
		LG				11/21/2011	-1.0000	71502	-1.0000		(\$319.90)

Transaction Type	Item ID/ Item Name	Warehouse	Reason	Employee ID	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
		Location ID		Location Code				Lot Code		
Issue	D2896-1 / Support	Main Warehouse	✓ 74377 -203 ✓	FAUT01		15.0000		15.0000		
		LG			11/21/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 76351 -203	DESJ02		35.0000		14.0000		
		LG053	✓ 76350 -203	DESJ02	12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				34.0000		13.0000		
		LG053	✓ 77108 -203	DESJ02	12/6/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				33.0000		12.0000		
		LG053	✓ 77273 -203	LAVO01	12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				32.0000		11.0000		
		LG053	✓ 77109 -203	DESJ02	12/9/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				31.0000		10.0000		
		LG053	✓ 77433	QUIR01	12/13/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				30.0000		9.0000		
		LG053	✓ 77434 ✓	QUIR01	12/19/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				29.0000		8.0000		
		LG053	✓ 77748	FAUT01	12/20/2011	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				28.0000		7.0000		
		LG053	✓ 77533	FAUT01	1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				27.0000		6.0000		
		LG053	✓ 77534	FAUT01	1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				26.0000		5.0000		
		LG053	✓ 78576	FAUT01	1/6/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				25.0000		4.0000		
		LG053	✓ 78574	FAUT01	2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse				24.0000		3.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)

Transaction Type	Item ID/ Item Name	Warehouse	Reason	Employee ID	Loc Trans Date	LocQtyPrior/ Location Qty	Lot Number	LotQtyPrior/ Lot Qty	Shelf Life Date	Extended Cost
		Location ID		Location Code				Lot Code		
Issue	D2896-1 / Support	Main Warehouse	✓ 78575	FAUT01		23.0000		2.0000		
		LG053			2/22/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 78573	GOLD01		22.0000		1.0000		
		LG053			2/24/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 80135	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	✓ 80134	FAUT01		22.0000		1.0000		
		LG053			3/7/2012	-1.0000	71502	-1.0000		(\$319.90)
		Main Warehouse	80585	GOLD01		22.0000		1.0000		
		LG053			3/23/2012	-1.0000	71502	-1.0000		(\$319.90)
Loc Transfer	D2896-1 / Support	Main Warehouse		GOLD01		0.0000		0.0000		
		LG053			11/30/2011	14.0000	71502	14.0000		\$4,478.55
		Main Warehouse		GOLD01		14.0000		14.0000		
		LG			11/30/2011	-14.0000	71502	-14.0000		(\$4,478.55)
WIP Receipt	D2896-1 / Support	Main Warehouse	71502	GOLD01		0.0000		0.0000		
		LG			10/3/2011	20.0000	71502	20.0000		\$6,397.93
						20.0000				\$6,397.93